

IN THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (currently amended) A method for the manufacture of heat exchangers and apparatuses having brazed parts, comprising the steps of:
  - (a) juxtaposing at least two parts to define one or more joints therebetween;
  - (b) supplying to said one or more joints an iron/chromium brazing filler metal;
  - (c) heating said juxtaposed parts and said brazing filler metal under appropriate conditions in order to melt said brazing filler metal; and
  - (d) cooling said juxtaposed parts and said brazing filler metal to produce a solid brazed joint of a brazed assembly; and
  - (e) conditioning said brazed parts by exposure to an elevated temperature in an oxygen-containing atmosphere for a time sufficient to substantially reduce the amount of nickel leaching into water or other fluids contacting the brazed joint of said brazed assembly.
2. (cancelled)
3. (currently amended) A method as recited by claim 21, wherein said oxygen-containing atmosphere is air.
4. (currently amended) A method as recited by claim 21, wherein said elevated temperature ranges from about 300°C to 600°C.

5. (original) A method as recited by claim 4, wherein said elevated temperature ranges from about 350°C to 500°C.
6. (original) A method as recited by claim 21, wherein said time ranges from about 8 to 24 hours.
7. (original) A method as recited by claim 1, wherein said iron/chromium brazing filler metal consists essentially of a composition having the formula  $Fe_aCr_bCo_cNi_dMo_eW_fB_gSi_h$  wherein the subscripts "a", "b", "c", "d", "e", "f", "g", and "h" are in atom percent and wherein, "b" ranges from about 5 to 20, "c" ranges from 0 to about 30, "d" ranges from 0 to about 20, "e" ranges from 0 to about 5, "f" ranges from 0 to about 5, "g" ranges from about 8 to 15, "h" ranges from about 8 to 15, and the sum "a"+"b"+"c"+"d"+"e"+"f"+"g"+"h"=100, the balance being incidental impurities present in an amount up to about 1 percent by weight of the total composition.
8. (currently amended) A process-method for joining two or more metal parts to form a brazed joint in a brazed assembly, comprising the steps of:
  - (a) juxtaposing said parts to define one or more joints therebetween;
  - (b) supplying to the one or more joints an iron/chromium brazing filler metal;
  - (c) heating said juxtaposed parts and said brazing filler metal to melt said brazing filler metal; and
  - (d) cooling said juxtaposed parts and said melted brazing filler metal to produce a brazed joint having braze parts; and

(e) conditioning the brazed parts by exposing said brazed joint to an elevated temperature, in an oxygen-containing atmosphere, for a sufficient time to substantially reduce the amount of nickel leaching into water or other fluids contacting the brazed joint in said brazed assembly.

9. (cancelled)
10. (currently amended) A method as recited by claim 98, wherein the oxygen-containing atmosphere is air.
11. (currently amended) A method as recited by claim 98, wherein said elevated temperature ranges from about 300°C to 600°C.
12. (original) A method as recited by claim 11, wherein said elevated temperature ranges from about 350°C to 500°C.
13. (currently amended) A method as recited by claim 98, wherein said time ranges from about 8 to 24 hours.
14. (original) A method as recited by claim 8, wherein said iron/chromium brazing filler metal consists essentially of a composition having the formula  $Fe_aCr_bCo_cNi_dMo_eW_fB_gSi_h$  wherein the subscripts "a", "b", "c", "d", "e", "f", "g", and "h" are in atom percent and wherein, "b" ranges from about 5 to 20, "c"

ranges from 0 to about 30, "d" ranges from 0 to about 20, "e" ranges from 0 to about 5, "f" ranges from 0 to about 5, "g" ranges from about 8 to 15, "h" ranges from about 8 to 15, and the sum "a"+“b”+“c”+“d”+“e”+“f”+“g”+“h”=100, the balance being incidental impurities present in an amount up to about 1 percent by weight of the total composition.

15. (cancelled)

16. (currently amended) A heat exchanger, comprising at least one joint brazed with  
~~as recited by claim 15, wherein said an~~ iron/chromium brazing filler metal  
consisting essentially of a composition having the formula  
 $\text{Fe}_a\text{Cr}_b\text{Co}_c\text{Ni}_d\text{Mo}_e\text{W}_f\text{B}_g\text{Si}_h$  wherein the subscripts "a", "b", "c", "d", "e", "f", "g", and "h" are in atom percent and wherein, "b" ranges from about 5 to 20, "c" ranges from 0 to about 30, "d" ranges from 0 to about 20, "e" ranges from 0 to about 5, "f" ranges from 0 to about 5, "g" ranges from about 8 to 15, "h" ranges from about 8 to 15, and the sum "a"+“b”+“c”+“d”+“e”+“f”+“g”+“h”=100, the balance being incidental impurities present in an amount up to about 1 percent by weight of the total composition.

17. (currently amended) A heat exchanger comprising at least two parts forming one of a plurality of brazed joints in a brazed assembly, said heat exchanger being produced by a process comprising the steps of:

- (a) juxtaposing said at least two parts to define one or more joints therebetween;
- (b) supplying to said one or more joints an iron/chromium brazing filler metal;
- (c) heating said juxtaposed parts and said brazing filler metal to melt the brazing filler metal; **and**
- (d) cooling said juxtaposed parts and said melted brazing filler metal to produce a brazed joint having brazed parts; and
- (e) conditioning the brazed parts by exposing said brazed joint to an elevated temperature, in an oxygen-containing atmosphere, for a sufficient time to substantially reduce the amount of nickel leaching into water or other fluids contacting the brazed joints of the brazed assembly.

18. (cancelled)

19. A heat exchanger as recited by claim 17, wherein said iron/chromium brazing filler metal consists essentially of a composition having the formula  $Fe_aCr_bCo_cNi_dMo_eW_fB_gSi_h$  wherein the subscripts "a", "b", "c", "d", "e", "f", "g",

and "h" are in atom percent and wherein, "b" ranges from about 5 to 20, "c" ranges from 0 to about 30, "d" ranges from 0 to about 20, "e" ranges from 0 to about 5, "f" ranges from 0 to about 5, "g" ranges from about 8 to 15, "h" ranges from about 8 to 15, and the sum "a"+"b"+"c"+"d"+"e"+"f"+"g"+"h"=100, the balance being incidental impurities present in an amount up to about 1 percent by weight of the total composition.

20-22. (cancelled)

23. (new) A method for the manufacture of heat exchangers and apparatuses having brazed parts, comprising the steps of:

(a) juxtaposing at least two parts to define one or more joints therebetween;

(b) supplying to said one or more joints an iron/chromium brazing filler metal consisting essentially of a composition having the formula  $Fe_aCr_bCo_cNi_dMo_eW_fB_gSi_h$  wherein the subscripts "a", "b", "c", "d", "e", "f", "g", and "h" are in atom percent and wherein, "b" ranges from about 5 to 10, "c" ranges from 0 to about 10, "d" ranges from 0 to about 10, "e" ranges from 0 to about 3, "f" ranges from 0 to about 3, "g" ranges from about 8 to 15, "h" ranges from about 8 to 15, the sum "g"+"h" ranges from about 18 to 25, and the sum "a"+"b"+"c"+"d"+"e"+"f"+"g"+"h"=100, the balance being incidental impurities present in an amount up to about 1 percent by weight of the total composition;

(c) heating said juxtaposed parts and said brazing filler metal under appropriate conditions in order to melt said brazing filler metal; and

- (d) cooling said juxtaposed parts and said brazing filler metal to produce a solid brazed joint of a brazed assembly.
24. (new) A method as recited by claim 23, wherein said brazing filler metal is in the form of a homogeneous, ductile ribbon.
25. (new) A method as recited by claim 23, further comprising the step of:
- (e) conditioning said brazed parts by exposure to an elevated temperature in an oxygen-containing atmosphere for a time sufficient to substantially reduce the amount of nickel leaching into water or other fluids contacting the brazed joint of said brazed assembly.

**IN THE SPECIFICATION**

Please amend the specification by adding the following paragraph at the beginning of the application:

**RELATED U.S. APPLICATION DATA**

This application is a divisional of U.S. Patent Application Ser. No. 10/171,132, filed June 13, 2002, now U.S. Patent No. 6,656,292.